

Date: Wednesday, 30/07/2008 5:32:45 PM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT FACING SEAT ASS'Y RH		
Job Number	40826			Part Number	: D412769044		
Estimate Number	13314			Drawing Number	: D412-769-2 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 30/07/2008 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 15/08/2008 Qty: 1 Um: Each		
Previous Run	: 40825						
Written By	:						
Checked & Approved By	<u>JUL 08 7 21</u>						
Comment	: Est rev A 08-05-12 new issue DD verified by:ec Est Rev:B 08-07-17 revB as per dwg DD verified by:ec						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 Pick Packing Kit			
2.0	D3782045	Back Leg Assembly	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Back Leg Assembly batch: <u>B40873-3</u> FF 08/08/27 ①			
3.0	D3782041	Front Inboard Leg Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Inboard Leg Assembly batch: <u>B40870</u> SP			
4.0	D3782044	Front Outboard Leg Assembly, RH	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Outboard Leg Assembly, RH batch: <u>B40872</u> SP			
5.0	D3783041	Lateral Brace Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Lateral Brace Assembly batch: <u>40874</u> SP			

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40826

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D3783043 Longitudinal Brace Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Longitudinal Brace Assembly

batch: B40875

SP

7.0 D3783045 Angle Brace Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle Brace Assembly

batch: B40876

SP

8.0 D3784041 Seat Support Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, Center

batch: B40877

SP

9.0 D3784043 Seat Support Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, LH

batch: B40878

SP

10.0 D3784044 Seat Support Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, RH

batch: B40879

SP

11.0 D37662 Front Rail, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Front Rail

batch: B40864

SP

12.0 D37663 Rear Rail



(A)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rear Rail

batch: B40865

8/8/26

SB

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40826

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 D37671 Upper Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch: B40864

SP

14.0 D37921 Seat Belt Eye Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Seat Belt Eye Bolt

batch: B40999

SP

15.0 AN415A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M101746

SP

16.0 AN45 13A EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch: M109013

SP

17.0 AN510A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M107534

(3) (4)

SP

18.0 AN513A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108167

8/8/27

SP

19.0 AN960JD10 Washer



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

batch: M109059

(or NAS1149D0363J) batch: M109059

6/1/27

FF 08/08/27

(1)

W/O:		WORK ORDER CHANGES				
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40826

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 AN960JD416 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M108161

50

(or NAS1149D0463J) batch: _____

21.0 AN960JD516 Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: M108672

50

(or NAS1149D0568J) batch: _____

22.0 AN52510R24 Screw



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Screw

batch: M108270

50

23.0 MS21042L3 Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

batch: M108761

50

24.0 MS21042L4 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M107499

50

25.0 MS21042L5 Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M108471

50

508122

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40826

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

26.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-2

FF 08/08/27

27.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/28 (1)

28.0 POWDER COATING POWDER COATING



M106442

(1X)

Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- Powder coat remainig of assembly grey as per dwg D412-769-2

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:15
320°
10:15

OVEN TEMPERATURE:

320°
10:15

FINISH TIME:

M 08/08/28

29.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



98 08/08/28 (X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-28 (X)

30.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0 D37751 Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guard
batch: 1340869

JB 08/08/28 (D)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40826

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
32.0	D37741	Seat Bottom, LH/RH
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Bottom, LH batch: <u>B40867</u>
33.0	D37743	Seat Back, LH/RH
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Bottom, LH batch: <u>B40868</u>
34.0	AN525 10R22	Screw
		Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Screw batch: <u>M107936</u>
35.0	AN960JD10L	Washer
		Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Washer batch: <u>M105793</u>
36.0	MS21042L3	Nut
		Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s) Nut batch: <u>M10870</u>
37.0	AN35A	Bolt
		Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Bolt batch: <u>M100188</u>
38.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- install remaining parts as per dwg D412-769-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40826

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
39.0	QC5	INSPECT WORK TO CURRENT STEP
		<i>8/08/29(80)</i>
Comment:	INSPECT WORK TO CURRENT STEP	
40.0	PACKAGING 1	PACKAGING RESOURCE #1
		<i>08/08/29 (xx)</i>
Comment:	PACKAGING RESOURCE #1	
	Identify and Stock	
	Location: <i>(DRAFT)</i>	
41.0	QC21	FINAL INSPECTION/W/O RELEASE
		<i>1/08/29 (xx)</i>
Comment:	FINAL INSPECTION/W/O RELEASE	

Job Completion



MF 08-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

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C

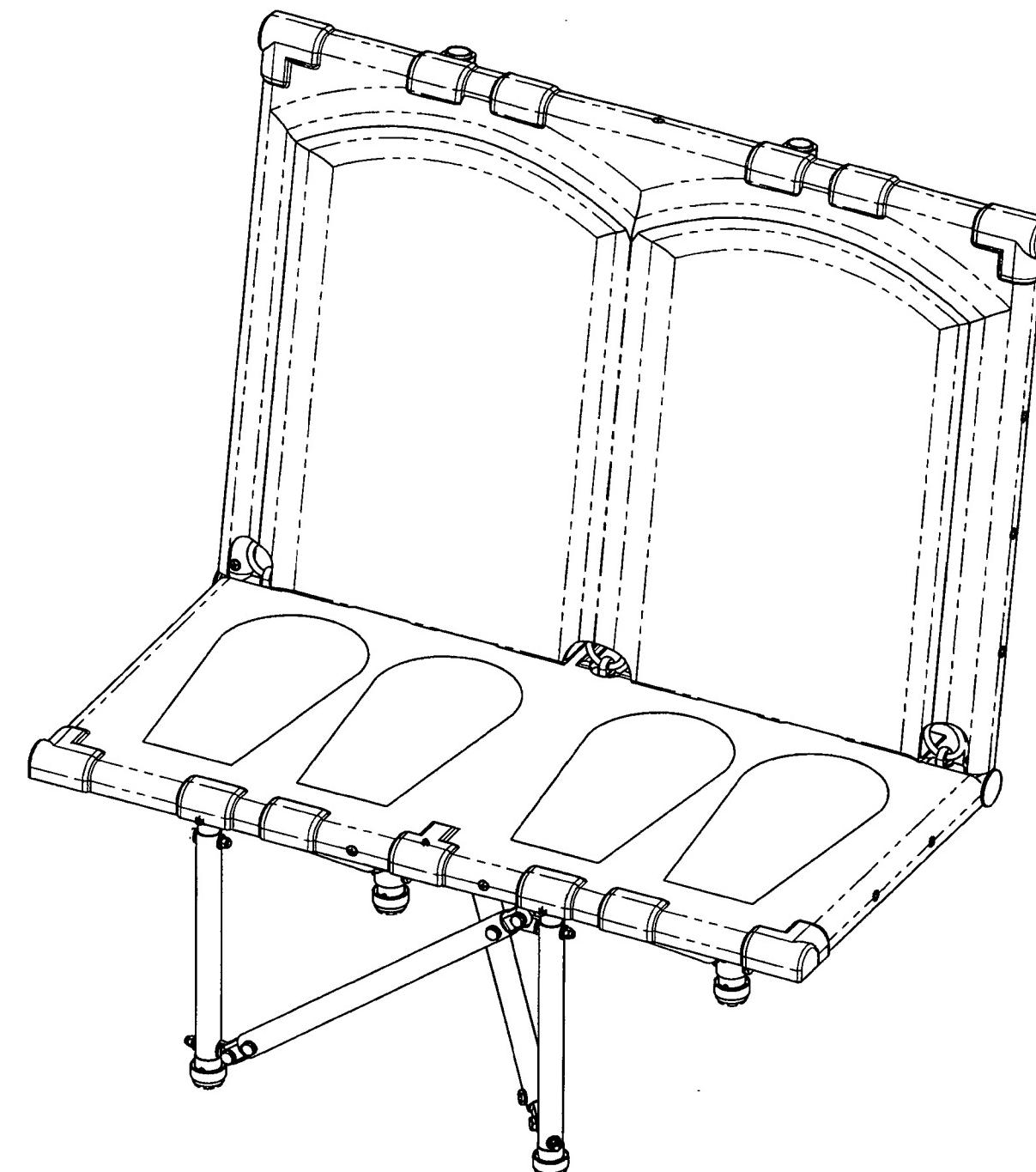
C

B

B

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A



D412-769-044 AFT FACING SEAT, RH

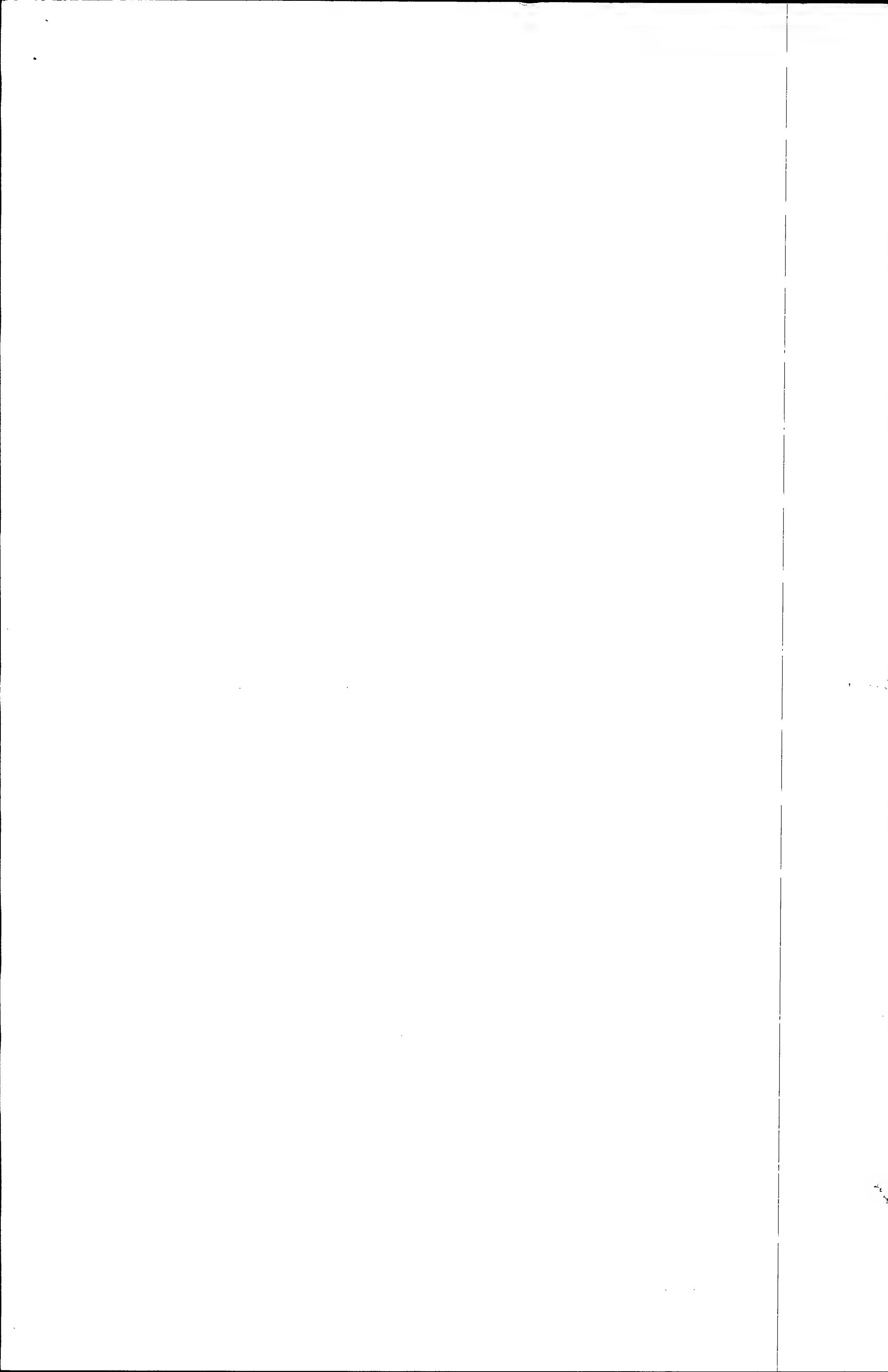
RELEASED
08-07-10 MPW

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SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 140820

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	MP	D412-769-2	SHEET 1 OF 7
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	AFT FACING SEAT ASSY, RH	
DATE	08.06.25	NTS	

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8 7 6 5 4 3 2 1



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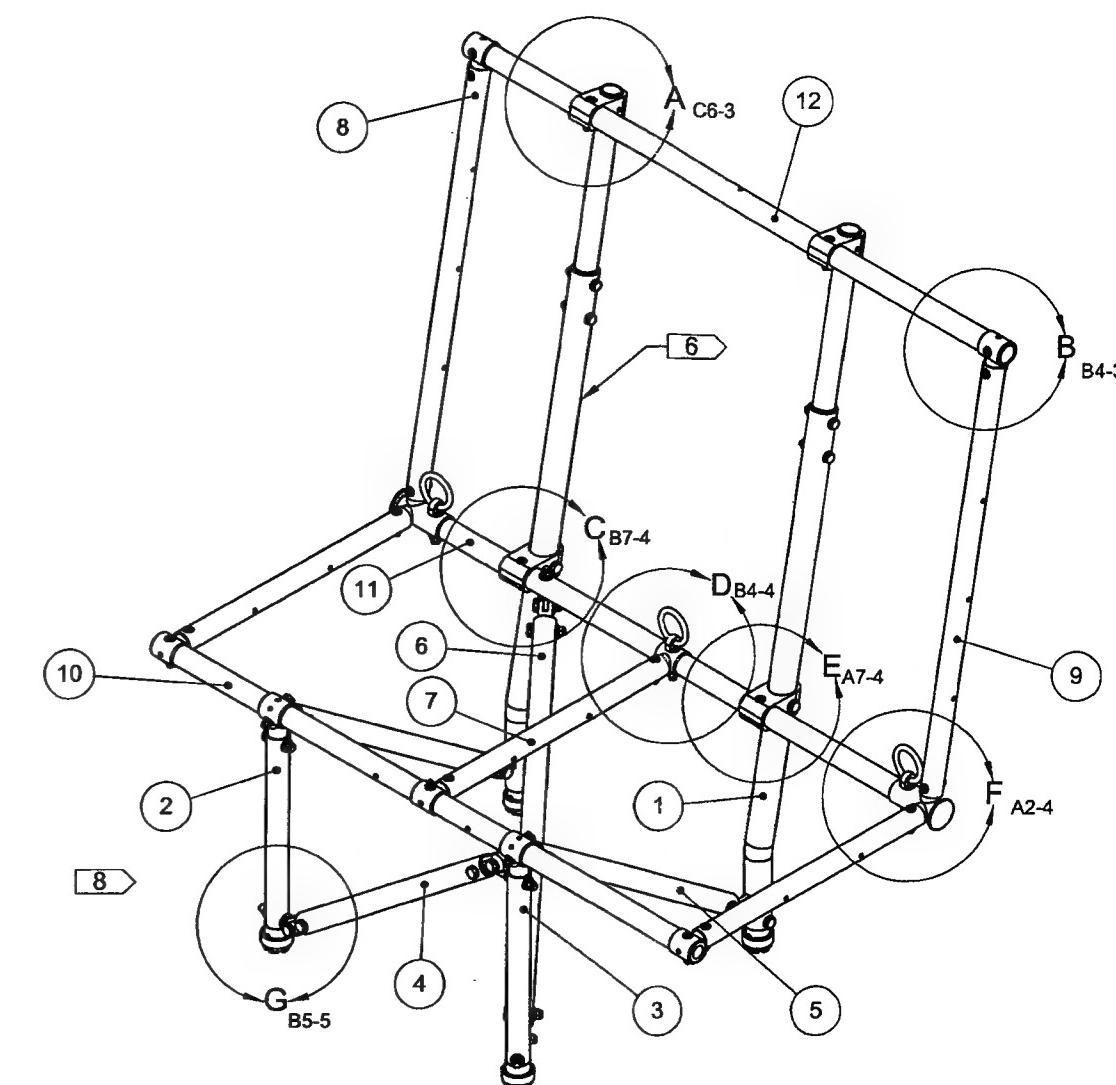
B

B

A

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-044	FRONT OUTBOARD LEG ASSY, RH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-2	FRONT RAIL, RH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20

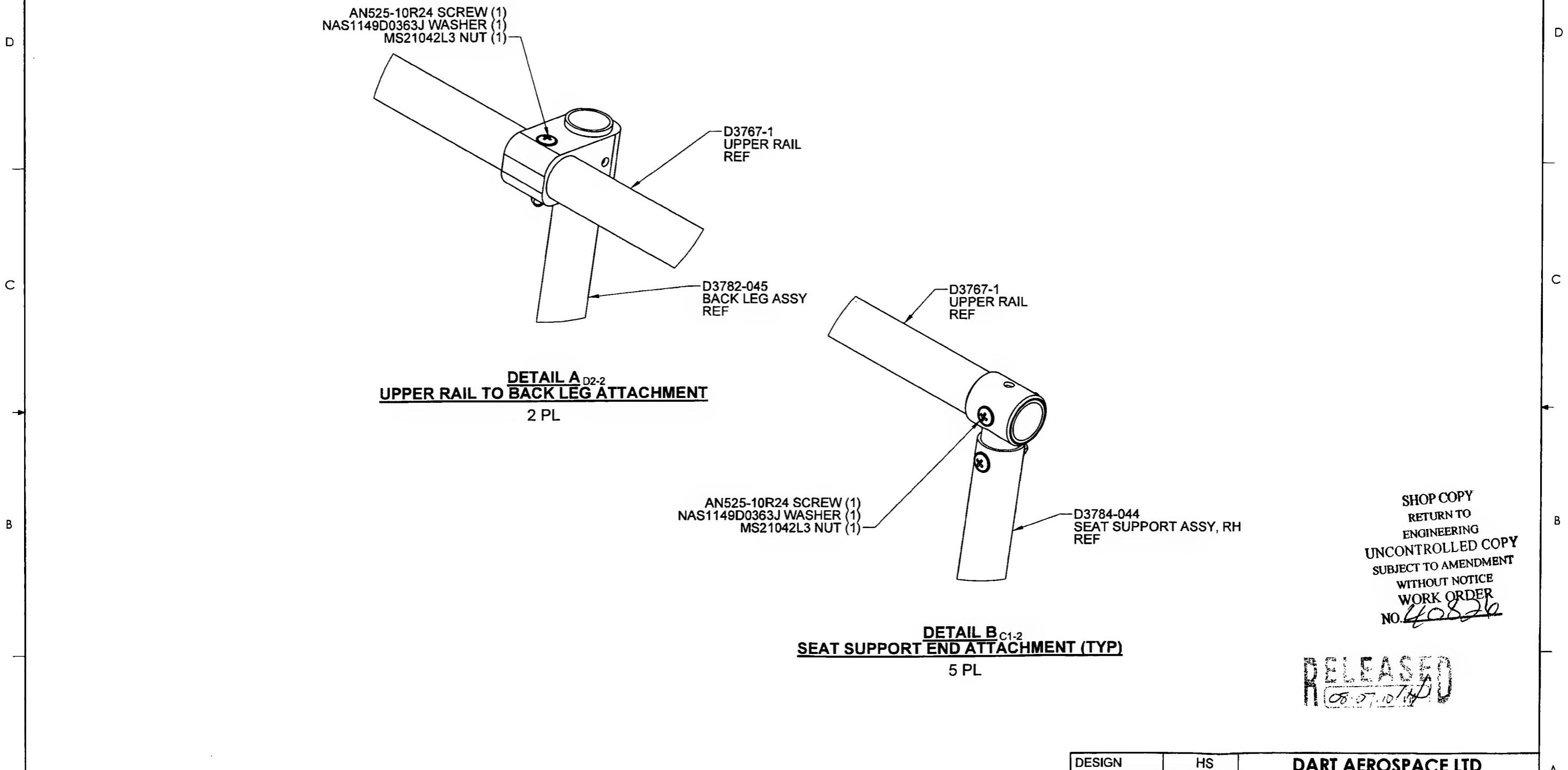
**D412-769-044 AFT FACING SEAT, RH**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40026

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[initials]</i>	DRAWING NO.	D412-769-2
MFG. APPR.	<i>[initials]</i>	REV. B	SHEET 2 OF 7
APPROVED	<i>[initials]</i>	TITLE	AFT FACING SEAT ASSY, RH
DE APPR.	<i>[initials]</i>	SCALE	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

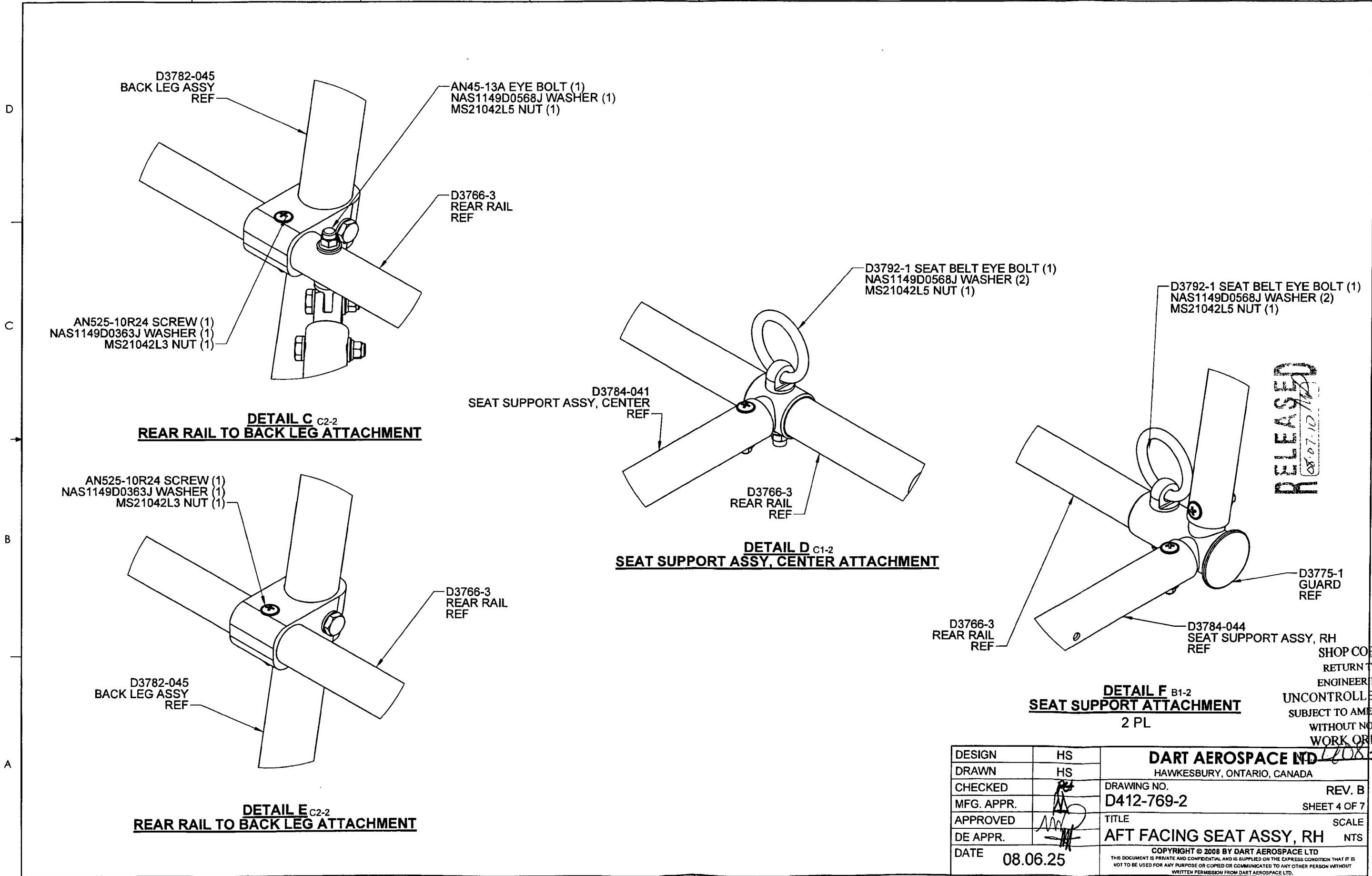
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1, -3). MASK FRONT LEGS PRIOR TO POWDER COAT
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
 - 7) WEIGHT: 30.0 lbs
 - 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

8 7 6 5 4 3 2 1



DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PJ	DRAWING NO.	
MFG. APPR.		D412-769-2	REV. B
APPROVED	MJ	TITLE	SHEET 3 OF 7
DE APPR.		AFT FACING SEAT ASSY, RH	SCALE NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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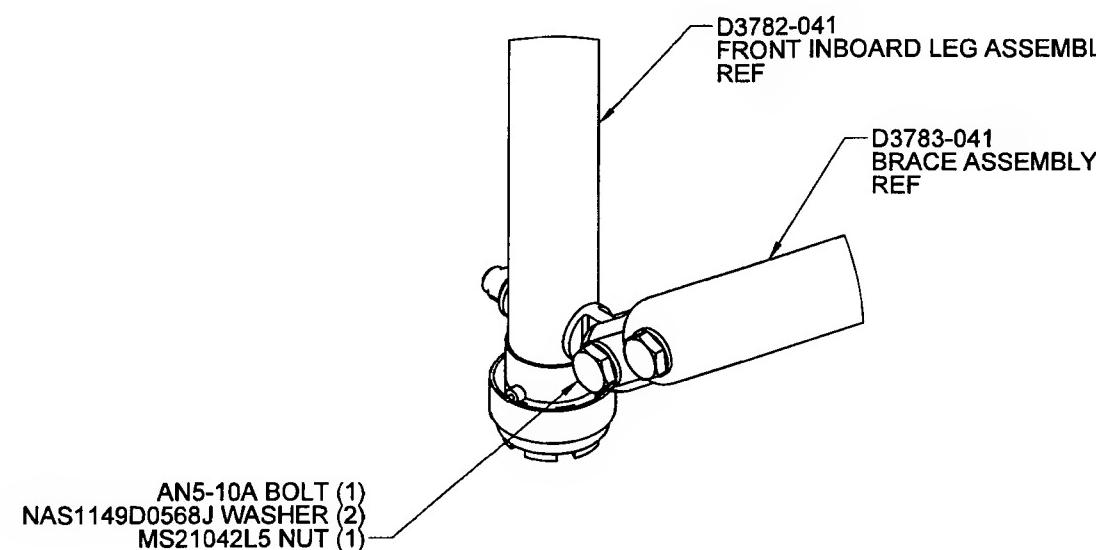
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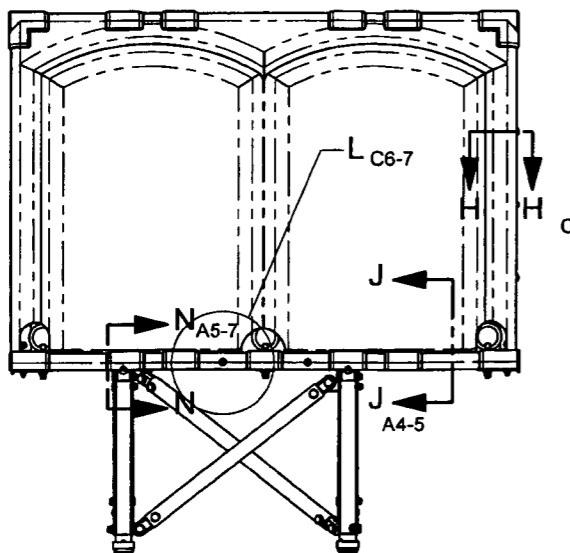
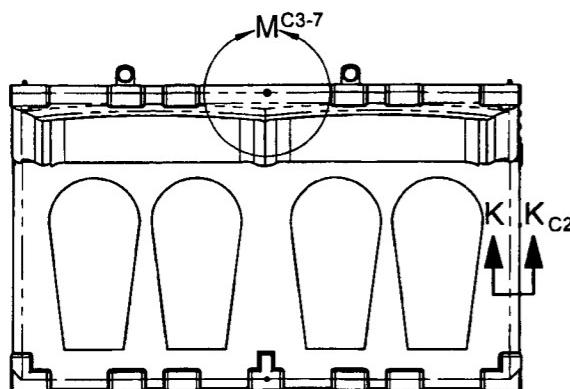
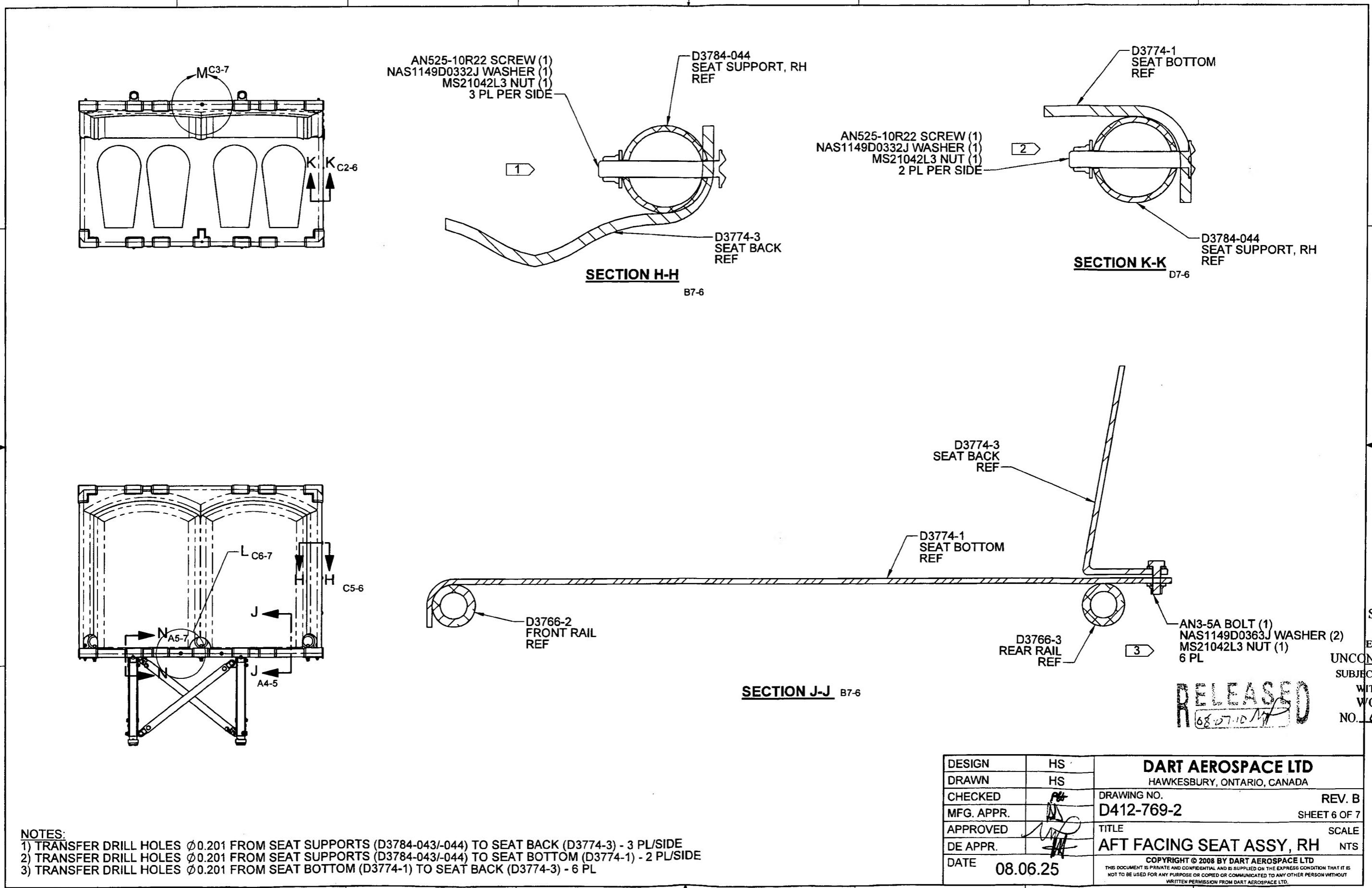
DETAIL G_{B3-2}
BRACE ATTACHMENT
6 PL

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *40820*

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D412-769-2 REV. B SHEET 5 OF 7
DRAWN	HS	
CHECKED	<i>P4</i>	
MFG. APPR.	<i>M</i>	
APPROVED	<i>SM</i>	
DE APPR.	<i>M</i>	
DATE	08.06.25	SCALE NTS

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8 7 6 5 4 3 2 1



AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
3 PL PER SIDE

D3784-044
SEAT SUPPORT, RH
REF

AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
2 PL PER SIDE

D3774-3
SEAT BACK
REF

B7-6

D3774-1
SEAT BOTTOM
REF

D3784-044
SEAT SUPPORT, RH
REF

SECTION K-K D7-6

D3774-3
SEAT BACK
REF

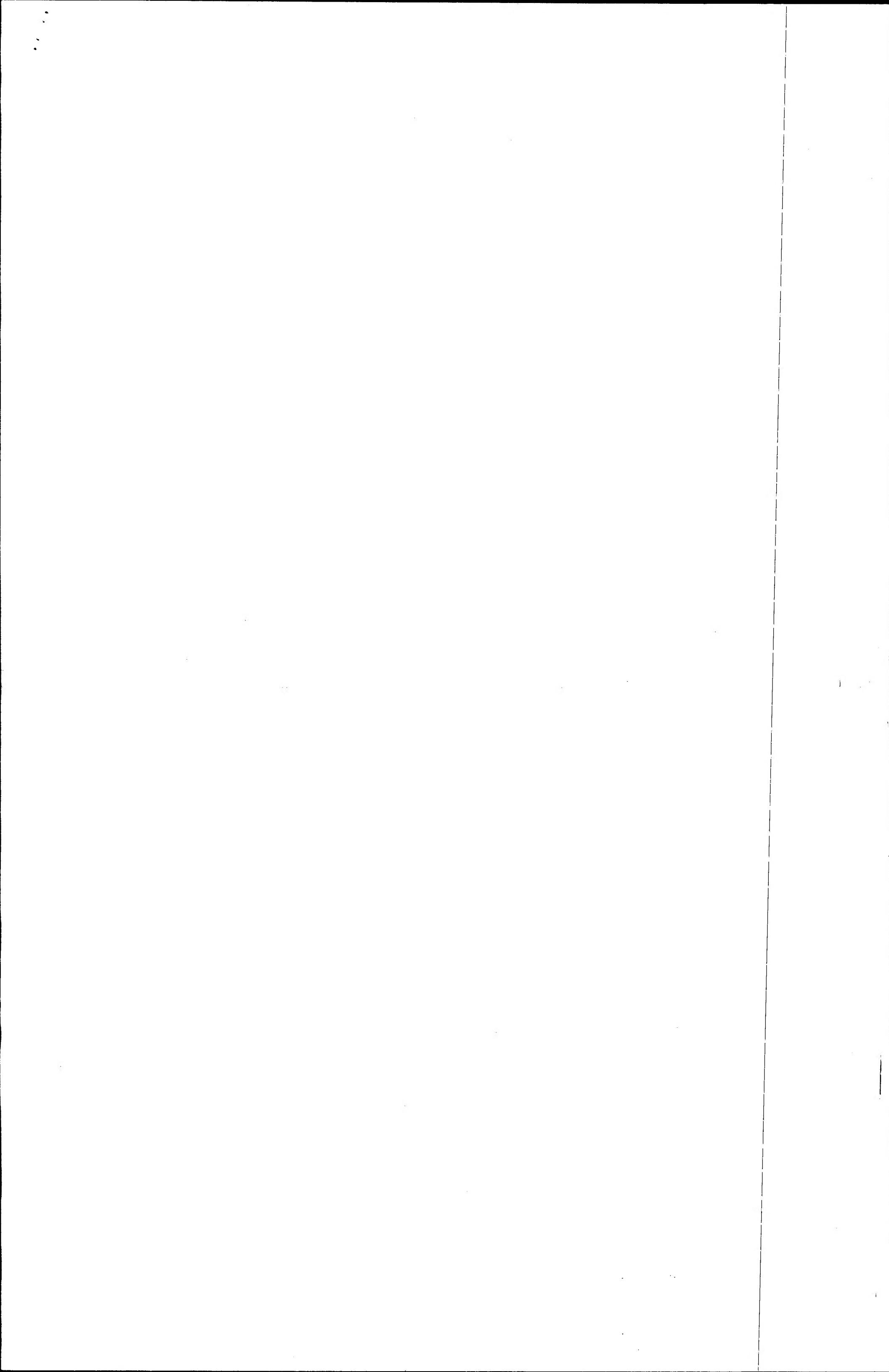
D3774-1
SEAT BOTTOM
REF

D3766-2
FRONT RAIL
REF

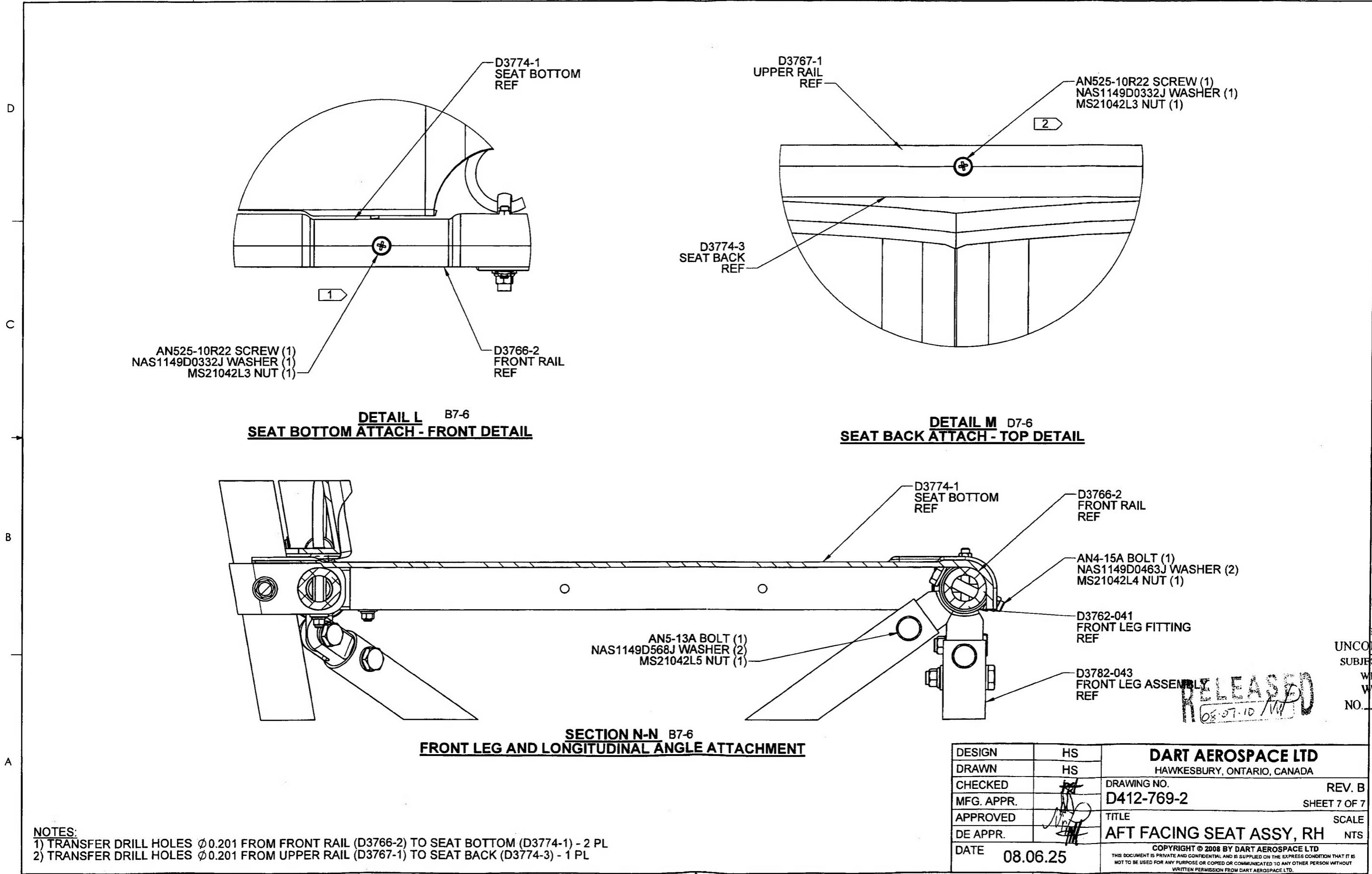
D3766-3
REAR RAIL
REF

AN3-5A BOLT (1)
NAS1149D0363J WASHER (2)
MS21042L3 NUT (1)
6 PL

RELEASED
680710/17



8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

